

Job Traveler

Job Number: 232167-01

Due Date: 01/30/2024



Sold PIONEER PIPE
To: 25 COLLEGE PARK COVE
JACKSON, TN 38301
United States

Ship
To: , TN
United States

Order No: 232167

Dated: 12/05/2023

Quote No: 20938

Customer: PIONEER309100

PO Num: B 24019753

Ship Via: LHACKE@PIONEERPIPE.COM

Priority: 3 - STANDARD

Part Number: *3CP36?Y

Product Code: CAP

Description: CP 36 .625-WPHY65

Master Job No:

52-96

Total Qty Open: 39 EA

Qty Posted: 0 EA

Qty To Make: 39

Start Date: 12/05/2023

Phone:

Contact: LUCAS FERGUSON

Fax:

Job Notes

(20) BCMU
B11008

(19) BCMT
B10850

CAPS COMING FROM 232171-01 IN PROCESS

Routing

Routed By:

Quantity 39

Step No Dept	Work Cntr / Vendor Operation	Description	Setup Time	Cycle Time	Total Time	Pieces Per Hour	--- Scheduled --- Start End		Run Quantity
10	M3 MACHINING	M3 Mill Machining					12/05/2023	12/11/2023	39



20	STAMP 1 STAMP	Stamping					12/11/2023	12/11/2023	39
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30	INSPECT 1 INSPECTION	Inspection 1					12/11/2023	12/11/2023	39
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Report Generated: 12/05/2023 11:46:15 AM



Time per Piece (HR):	0.00	0.00	0.00	0.00
Total Time for Job (HR):	0.00	0.00	0.00	

Materials List

						Quantity:	39
-----Quantity-----							
<u>Needed</u>	<u>On Hand</u>	<u>Posted</u>	<u>Short</u>	<u>Unit</u>	<u>Description</u>	<u>Sub- Assy</u>	<u>Vendor</u>

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCMT
36 - .625
WPHY65
232167-01

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCMU
36 - .625
WPHY65
232167-01

FORM BY PRESS

IF ORDER SIZE IS LARGER THAN FURNACE LOAD, SERIALIZE UNDER CUTTER STAMP PRIOR TO HEAT TREAT

HEAT TREATMENT PER QCP 8.1 REV.1 : (WITH TEST MAT'L B-_____)

HEAT TREAT 1/2 HR @ 1650°F **WATER QUENCH** FURNACE LOAD # _____

TEMPER 1 HR @ 1100 °F - AIR COOL FURNACE LOAD # _____

SHOTBLAST TO NEAR WHITE FINISH

MACHINE PER MSS-SP-75-19

CONDITION GRIND

STAMP AND SERIALIZE PER SPEC WITHIN 2" OF END OF FITTING, IF CE IS >.42, MUST BE STAMPED

COAT WITH RUST PREVENTATIVE

CUSTOMER INSPECTION OR WRITTEN RELEASE REQUIRED BEFORE SHIPMENT

END PROTECT/PALLETIZE MUST HAVE PLASTIC VENTED END CAPS

SEND MTR'S FOR APPROVAL

MTR MUST INCLUDE HEAT TREAT CHARTS

ARE FITTINGS Y60 OR Y65, IF SO, MUST BE Q & T'D

HEAT TREATMENT CHARTS MUST BE PART OF MTR

Cr	Mo	Ni	Cu	SUM (</=.65)
<u>0.086</u>	<u>0.026</u>	<u>0.064</u>	<u>0.079</u>	<u>0.255</u>

Cb	V	SUM (</=.12)
<u>0.04</u>	<u>0.047</u>	<u>0.087</u>

Carbon: 0.148 dictates which CE formula to use, CE= 0.408 Ladle CE: 0.414

Yield: 71,610 Tensile: 88,020 Yield/Tensile Ratio (0.88Max): 0.81

CE MAX .45; MUST BE GRANTED APPROVAL IF OVER .420

YIELD LIMITATIONS, GR.B, 35-67, Y42, 42-67, Y46, 46-67, Y52 AND GREATER, 20 OVER MINIMUM IMPACTS, AT +20 THEN 30/22.5

PRIOR TO SHIPMENT, ONE ELECTRONIC AND ONE HARD COPY OF MTR MUST BE SUBMITTED

1100F MINIMUM STRESS RELIEF TEMP

PACKING MUST INCLUDE END PROTECTORS

S:\PUBLIC\TRAVELER\S:\PUBLIC\TRAVELER\Southern Cal Gas (Sempra) 52-96\SCG TRAVELERS.XLSX